

Work Order ID 133561

Wednesday, June 10, 2015 12:44:15 PM

133561

Page 1

Item ID: D4983-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Cargo Hook Assembly
Start Date: 6/10/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/10/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: MLS Date: JUN 10 2015 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4983	F								

100

0.00

100

Purchasing

Memo

0.00

Purchasing

ISSUE PO: 29013
TO: RED BARN (DART EUGENE)
C OF C IS REQUIRED

CL JUL 02 2015

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

IX 8015-08-17

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

ENSURE THAT D5066-1/-13 PLACARDS ARE INSTALL

REF. RED BARN BATCH #: 01-16263-A-19

DAS
38
9-89

① AUG 25 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
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Past Expiry Date ☐	Manufacturing Process ☐																								
Misidentified ☐	Past Due ☐	OTHER : _____																							

Wednesday, June 10, 2015 12:44:15 PM

1.3.3.561

Page 2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Cargo Hook Assembly

Stop *NS2*

Start Date: 6/10/2015 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 6/10/2015 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

Identify as per dwg & Stock Location:

0.00

130

Packaging

Memo

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

AUG 28 1989

MCS AUG 28 2015

SA 120150828

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Wednesday, June 10, 2015 12:44:18 PM

133561

D4983-041

Start Date: 6/10/2015

Required Date: 6/10/2015**Start Qty: 1.00**

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 14-03-022 JLM VERIFIED BY:DD IPP
REV:B 15.03.26 AS PER DWG REV.F DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4983-041P		Purchased	No				Each	0.0000		1			

D4983-041P

Cargo Hook Assembly

1X SP15-C8-17

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

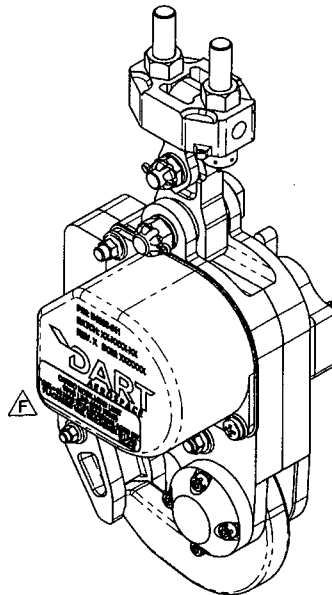
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4983-041	CARGO HOOK ASSY
1	1	D4984-041	HOOK SIDE PLATE ASSY
2	1	D4985-041	HOOK SIDE PLATE ASSY
3	1	D4986-1	CARGO HOOK LOCK
4	2	D4987-1	DUST SHIELD
5	1	D4988-1	KEEPERLESS ADAPTOR
6	1	D4989-1	LATCH SHAFT
7	1	D4990-041	ACTUATOR ASSEMBLY
8	1	D4991-1	LATCH ROLLER PIN
9	1	D4992-1	LATCH ROLLER
10	1	D4993-1	LATCH ROLLER DU BEARING
11	1	D4994-1	LATCH
12	2	D4995-1	ACTUATOR BUSHING
13	1	D4996-041	HOOK ASSEMBLY
14	1	D4997-1	LOAD BEAM BUMPER
15	2	D4998-1	LOCK BUMPER
16	1	D4999-1	CLOCK SPRING COVER
17	1	D5000-1	CLOCK SPRING
18	1	D5001-1	LOCK SPRING
19	2	D5002-1	LINK PIN
20	1	D5003-1	LINK
21	1	D5005-1	SOLENOID COVER GASKET
22	1	D5006-1	SOLENOID COVER
23	1	D5007-1	MANUAL RELEASE COVER
24	1	D5009-1	ACTUATOR SPRING
25	1	D5010-041	HOOK INTERFACE ASSY
26	1	D5011-041	HOOK SOLENOID ASSY
27	2	D5013-3	BUSHING
28	1	D5020-1	WIRE GUIDE/GRIP
29	1	D5044-1	DOWEL PIN
30	2	D5044-3	DOWEL PIN
31	2	D5045-1	SPLIT DU BEARING
32	1	D5056-1	HOOK PIN
33	2	D5057-1	NYLON WASHER
34	2	D5057-3	NYLON WASHER
35	1	D5065-1	HOOK MANUAL RELEASE LEVER
36	1	D5066-1	PLACARD
37	1	D5066-13	PLACARD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: LASER ETCH P/N D4983-041, BATCH XX-XXXX-XX, REV. X, DOM XX/XXXX
LOCATE APPROX AS SHOWN USING APPROX LETTERING HEIGHT
AS SHOWN, PER DART EUGENE SPEC QMSI-6.2.2.
- 7) WEIGHT: 5.50 lbs
- 8) WIRING INSTALLATION PER AC43.13-1B CHAPTER 11

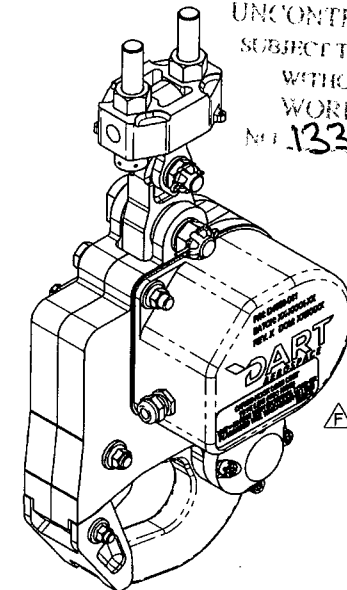
ITEM	QTY -041	P/N	DESCRIPTION
38	1	AN3C15A	BOLT
39	1	AN310C6	NUT, CASTELLATED
40	2	AN4C15A	BOLT
41	1	AN4C17A	BOLT
42	2	MS16624-4028	RETAINING RING
43	4	MS16624-5012-1	RETAINING RING
44	1	MS171532	SPRING PIN
45	3	MS21043-3	NUT, SELF-LOCKING
46	3	MS21043-4	NUT, SELF-LOCKING
47	1	MS24665-153	COTTER PIN
48	1	MS24694-C7	SCREW, CSK 100°
49	8	MS24674-9	SOCKET HEAD CAP SCREW
50	1	MS27039C1-08	SCREW, PAN-HEAD
51	4	MS35338-137	LOCK WASHER
52	5	NAS1149C0363R	WASHER
53	6	NAS1149C0463R	WASHER
54	1	NAS1149C0663R	WASHER
55	1	NAS1149C0863R	WASHER
56	1	D5116-5	WIRE M22759/41-14-9
57	1	D5116-7	WIRE M22759/41-14-9
58	1	1-480319	CONNECTOR
59	1	XPF-1/8	EXPANDABLE SLEEVE - 48" LONG
60	2	BT1.5I-M	TIE WRAP



D4983-041 CARGO HOOK ASSY

RELEASE

2015 MAR 26
A.P. EGN 15-554



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 133561 ML5
15-06-10

F	D5066-13 WAS D5066-5 (ZN A5-1, C2-1, B8-1 AND C4-3)	AK	15.03.02
E	ADDED ITEMS 56, 57, 58, 59, 60 TO BOM (ZN C5-1). ADDED NOTE 8 (ZN A8-1). UPDATED D5066-5 PLACARD (ZN A5-1, C2-1 AND C4-3). ADDED SHEET 4 (BUILD SEQUENCE 4).	AK	15.02.06
D	ITEM 50 WAS MS27039C0814 (DRAFTING ERROR). ADDED NOTE 6.	AJS	14.12.15
C	PICTORIAL UPDATE FOR CHANGES TO D5010-041 SUB ASSY. PICTORIAL UPDATE TO ITEM 28. ADDED ITEM 37 & 38. QTY FOR ITEM 44 WAS 4 (-9 DELETED). REDESIGNED D4985-041, D5007-1 AND D5065-1 AND UPDATED RELATED HARDWARE LENGTHS. ALL NASM HARDWARE REPLACED WITH AN/MS HARDWARE.	AJS	14.06.24
B	SHT 1 PARTS LIST: ITEM 42 WAS -151. ADDED ITEM 43. QTY FOR ITEM 44 WAS 8. ITEM 47 PART NUMBER WAS NAS1149C0832R. ITEM 51 PART NUMBER WAS NAS1149C0816R. ITEM 52 PART NUMBER WAS NASM24694-C4. REASON: DRAFTING ERROR.	AJS	14.03.13
A	NEW ISSUE	AJS	14.02.18
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	RF	DRAWING NO.	REV. F
MFG. APPR.	JLM	D4983	SHEET 1 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS-4	CARGO HOOK ASSY	NTS
DATE	15.03.02	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

8 7 6 5 4 3 2 1

D

C

B

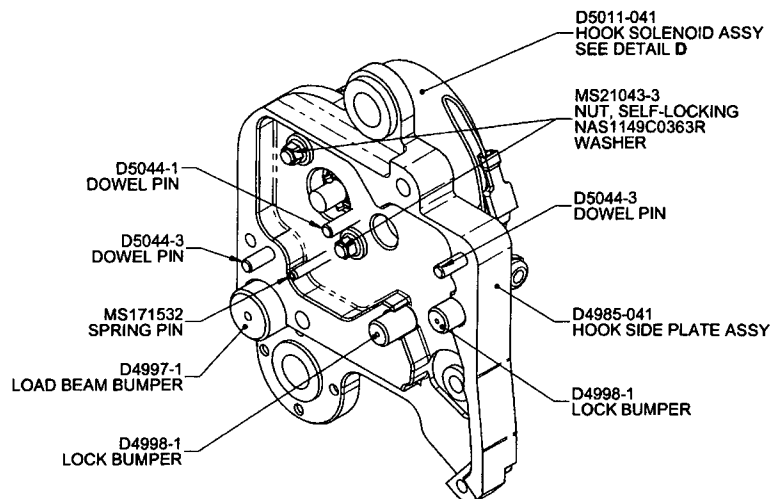
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D

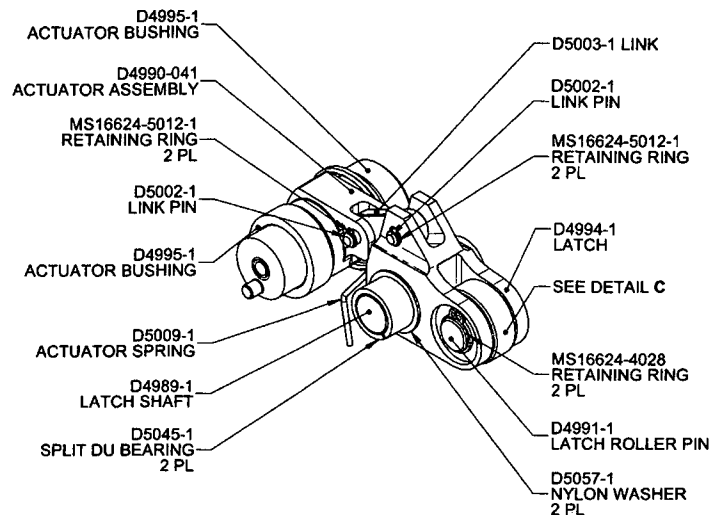
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B

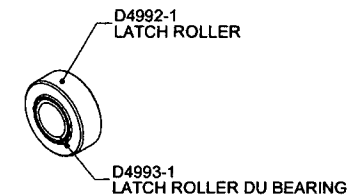
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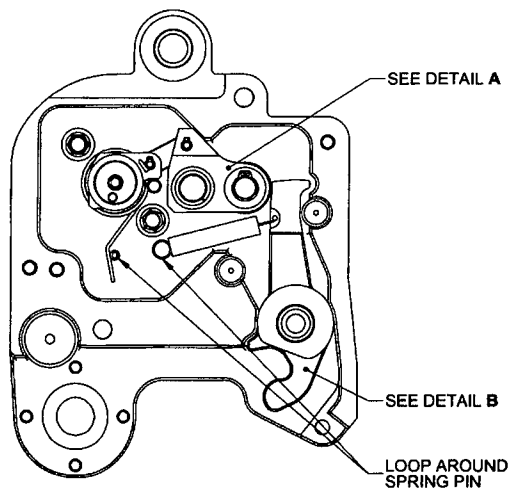
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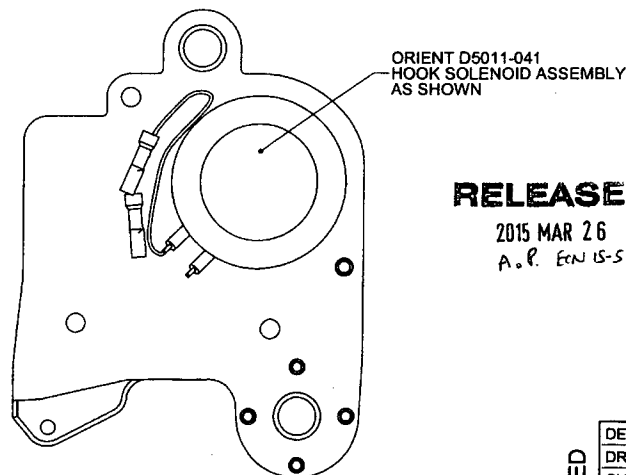
DETAIL A



DETAIL C



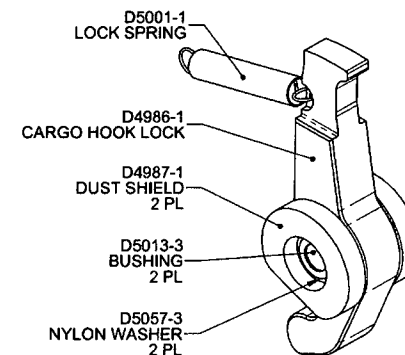
BUILD SEQUENCE 2



DETAIL D

RELEASED

2015 MAR 26
A.P. EEN 15-557



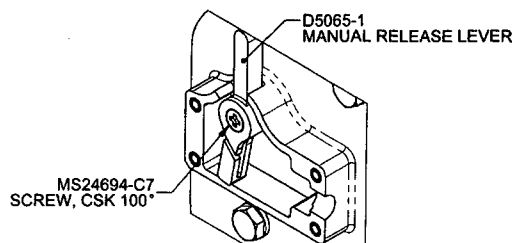
DETAIL B

APPROVED

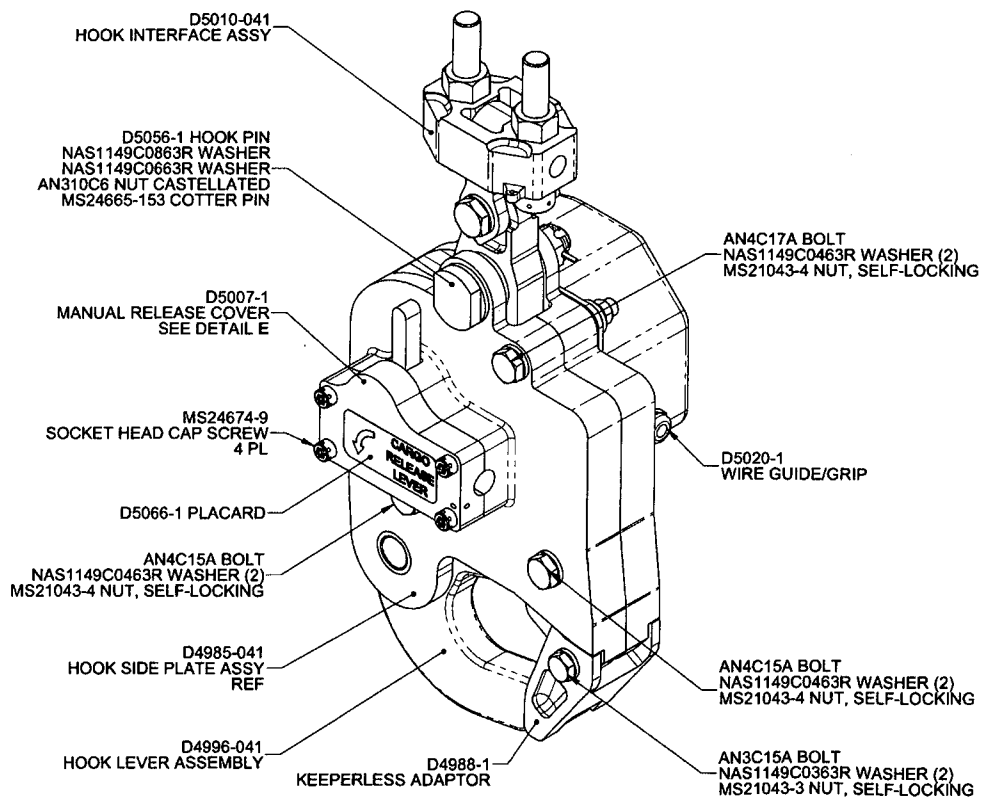
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AK	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. F
MFG. APPR.	JLM	D4983	SHEET 2 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CARGO HOOK ASSY	NTS
DATE	15.03.02	COPYRIGHT © 2014 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

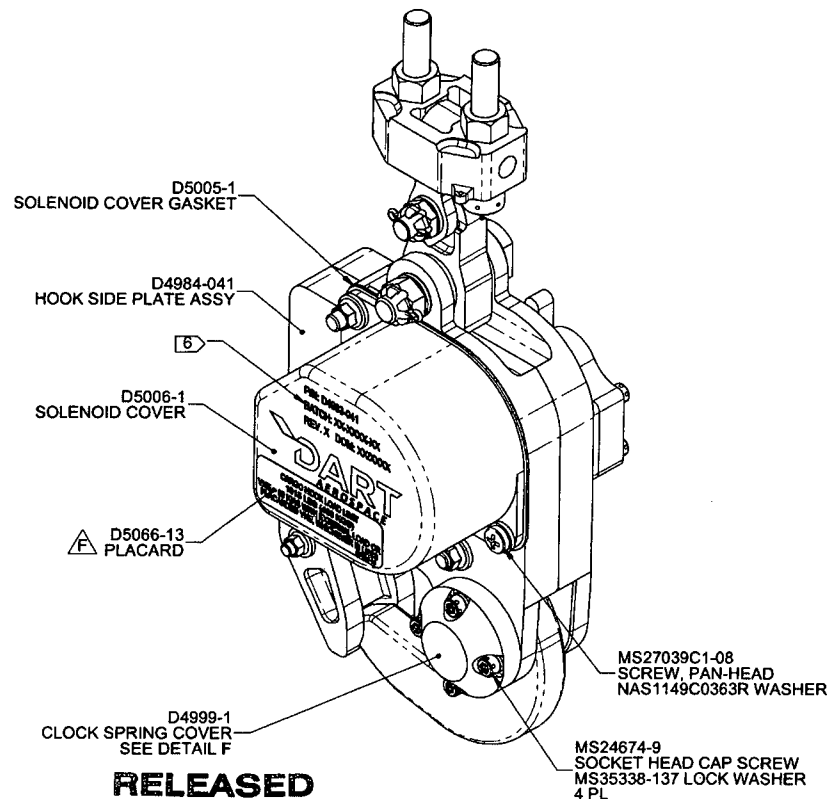
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DETAIL E

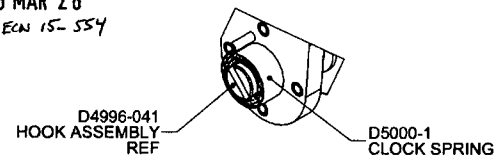


BUILD SEQUENCE 3



RELEASED

2015 MAR 26
A.P. EGN 15-554



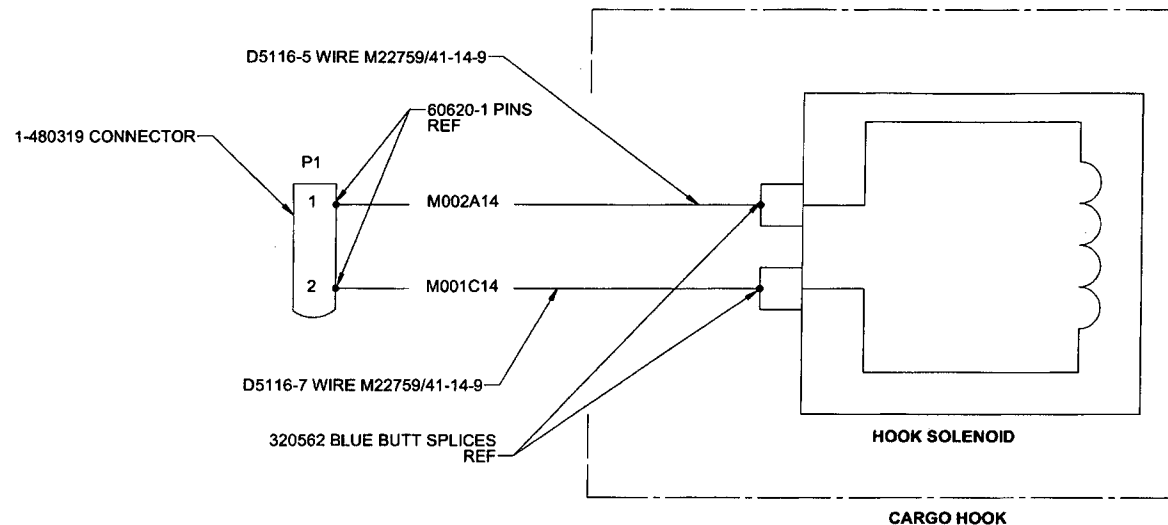
DETAIL F

APPROVED	DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	AK		
	CHECKED	RF	DRAWING NO.	REV. F
	MFG. APPR.	JLM	D4983	SHEET 3 OF 4
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	CARGO HOOK ASSY	NTS
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8 7 6 5 4 3 2 1

BUILD SEQUENCE 4 INSTRUCTIONS:

1. REMOVE D5006-1 SOLENOID COVER
2. INSTALL PINS ON THE D5116-5/-7 WIRES TO THE 1-480319 CONNECTOR. SEE FIGURE BELOW FOR DETAILS
3. INSTALL XPF-1/8 EXPANDABLE SLEEVE AT THE CONNECTOR END AROUND D5116-5/-7 WIRES AND SECURE USING A SMALL TIE WRAP
4. INSTALL D5116-5/-7 WIRES AND XPF-1/8 EXPANDABLE SLEEVE THROUGH D5020-1 WIRE GUIDE/GRIP ON THE SOLENOID COVER
5. INSTALL TIE WRAP ON EXPANDABLE SLEEVE AND WIRES INSIDE D5006-1 SOLENOID COVER
6. CONNECT D5116-5/-7 WIRES TO SOLENOID WIRES USING 320562 BLUE BUTT SPLICES
7. RE-INSTALL D5006-1 SOLENOID COVER
8. TIGHTEN D5020-1 WIRE GUIDE/GRIP



BUILD SEQUENCE 4

RELEASED

2015 MAR 26

A.P. Ecn 15-554

APPROVED

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	RF	DRAWING NO.	REV. F
MFG. APPR.	JLM	D4983	SHEET 4 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CARGO HOOK ASSY	NTS
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO29013**

Purchase Order Date 7/2/2015 1:26:29 PM

PO Print Date 8/17/2015

Page Number 1 of 3

Order From :

VU-RED001

RED BARN MACHINE INC.
190 S DANEBO AVE.
EUGENE, OR 97402
USA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	541-344-9953	Customer POID	
Ship To Contact		Customer Tax #	10127-2607
Ship To Phone		Terms	Net 30
Ship Via:	FedEx Overnight collect	Currency	USD
Ship Acct:		FOB	Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D4983-041P AS PER DWG D4983 REV. F B133553,B133554,B133555,B133556,B133557,B133558,B133559,B133560,B133561,B133562	Cargo Hook Assembly	8/21/2015 Yes 8/21/2015	FN	10.00 Each	\$1,500.00	\$15,000.00
Line Total:							\$15,000.00
2	D5051-041P AS PER DWG D5051 REV. C B133563	Cyclic Switch Housing Assembly	8/21/2015 Yes 8/21/2015	FN	10.00 Each	\$300.00	\$3,000.00
Line Total:							\$3,000.00

Note:

8/17/2015

Mission
Ready.



190 S Danebo Ave
Eugene, OR 97402
USA
Tel: 541.334.9953
Fax: 541.344.3863

Certificate of Conformance

Customer: DART Aerospace LTD. (Hawkesbury)

Purchase Order: 29013

Part Number	Description	Quantity	Batch
D4983-041P	Cargo Hook Assembly	1	01-16263-A-11
D4983-041P	Cargo Hook Assembly	1	01-16263-A-12
D4983-041P	Cargo Hook Assembly	1	01-16263-A-13
D4983-041P	Cargo Hook Assembly	1	01-16263-A-14
D4983-041P	Cargo Hook Assembly	1	01-16263-A-15
D4983-041P	Cargo Hook Assembly	1	01-16263-A-16
D4983-041P	Cargo Hook Assembly	1	01-16263-A-17
D4983-041P	Cargo Hook Assembly	1	01-16263-A-18
D4983-041P	Cargo Hook Assembly	1	01-16263-A-19
D4983-041P	Cargo Hook Assembly	1	01-16263-A-20

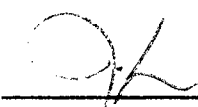
Packing Slip Number: 18559

SP15-08-17

ALL MATERIALS, PARTS, COMPONENTS HAVE BEEN INSPECTED AND HAVE BEEN MANUFACTURED TO THE DRAWINGS LISTED ON :

D4983 Rev F

Date of MFG 5-16-2015

Approved By: 

Date: 8-10-2015

Quality Assurance Manager

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Mission
Ready.